

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025724**Date Inspected:** 27-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

CWI Name:	Mr. Shi Stone		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	OBG 13BE, 13CW		

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

This Quality Assurance (QA) Inspector has performed documentation review of the Green Tag system utilized by American Bridge/Flour (ABF) and Caltrans METS. This QA Inspector has Identified Complete Joint penetration (CJP), Partial Joint Penetration (PJP), and Fillet Welds in Lift 13BE. He has also verified the Non-Destructive Testing requirements for each weldment that includes the NDT process (UT, MT, and RT) and the percentage required by the contractor to perform. These items are within the Contract special provision, CCO 22 and within compliant of CCO 77. This information has been documented and compiled in a Green Tagging spread sheet that is located on the Caltrans Team China Z; drive.

BLAST BAY 4

This inspector during Post Blast Quality Assurance Inspection, Visual Testing (VT) of internal OBG areas including, Side Plate, Floor Beam, and Longitudinal Diaphragm from PP 124.0 to East end of segment 13CW, between North side of segment from LD to EP. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel. Areas which require welding marked and masked off. The details are as follows:

- Piping porosity located in fillet weld SEG3015C-087, PP124.5
- Torch cut gouge in side plate SP3096A near hold back weld CA3016A-102
- Missing weld at edge beam stiffener to floor beam, fillet weld number SEG3015C-153
- Unacceptable weld profile, hold back fillet weld SEG3015C-119

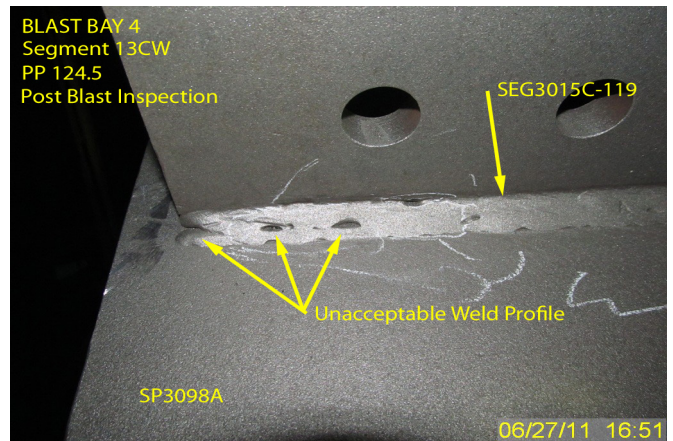
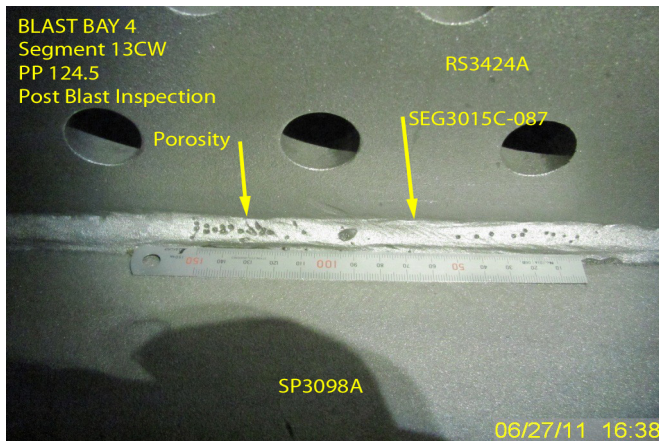
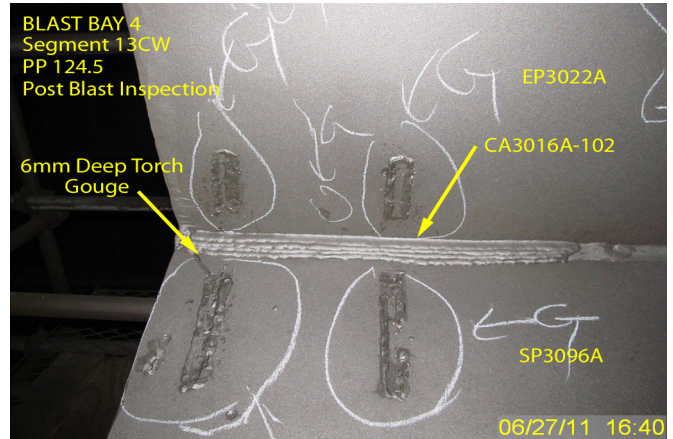
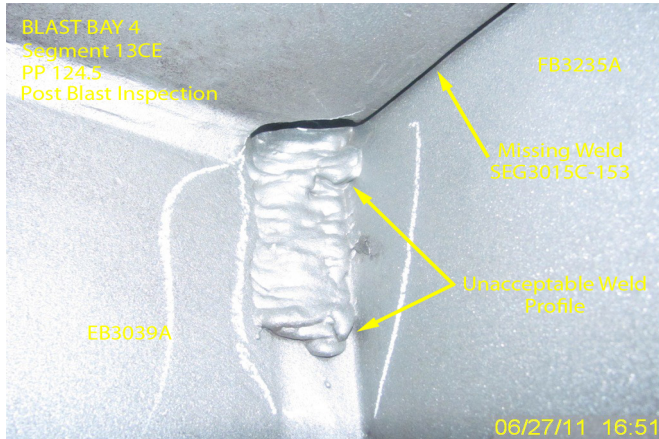
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All welds visually inspected appeared to be in general compliance with the applicable contract documents.

The Location of OBG13W is at blast bay 4.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Spoke with AB/F QC Mr. Shi Stone at 2210 regarding defects and missing welds observed during post blast inspections of OBG 13W.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Combs,Dennis

Quality Assurance Inspector

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Reviewed By: Riley, Ken

QA Reviewer